

Work Order ID 53040

October 22, 2009 10:52:22 AM



Page 1

Item ID: D3137-045
Revision ID: F
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 10.00
Required Date: 30/10/2009 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Run Start



Approvals: Process Plan: RL Date: 09-10-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3137	Rev F								
100	BAND SAW	0.00				10	0		
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blanks: (.500" x 2.000") 4.400" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00				10	0		
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo 1-Machine D3137-9 as per Folio FA621 and Dwg D3137 Identify as D3137- 9□2-Deburr□3-Scribe batch number								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		
	QC	0.00							
Quality Control	Memo								

Work Order ID 53040

Page 2

October 22, 2009 10:52:23 AM

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Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	JL 09/11/10						
140 Small Fab Small Fab	Small Fab Memo Assemble D3137-045 as per Dwg D3137	0.00 0.00	EB 09/11/11						
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	EB 09/11/11			10	0		

EB 09/11/11 (10)

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Page 3

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Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 235B

0.00



Packaging

Memo

0.00

Packaging

9/11/11 SP 10x7

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/11 [Signature]
ME
09-11-11

Picklist Print

Page 1

October 22, 2009 10:52:28 AM

Work Order ID: 53040

Parent Item: D3137-045RevF

Parent Item Name: Bracket Assembly

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24694-S101

Purchased

No

100

Each

100.0000

10.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

103338

5

110363

95

140

Each

17.0000

10.0000

D3137-3RevF

Manufactured

No



Guide

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

39449

3

39628

14

140

Each

37.0000

10.0000

D3137-5RevF

Manufactured

No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

10536

1

24547

2

42270

2

46740

32

Picklist Print

Page 2

October 22, 2009 10:52:28 AM

Work Order ID: 53040



Parent Item: D3137-045RevF



Parent Item Name: Bracket Assembly

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B0.500X02.000		Purchased	No			140	f	83.2300	3.8589			
17-4 SS Bar .500 x 2.00												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	83.23	
100843	13.01	
103089	18.7	mut 09/11/09 3.8589
14932	26.63	
19572	24.89	

DART AEROSPACE LTD		Work Order:	53040
Description: Bracket		Part Number:	D3137-9
Inspection Dwg: D3137 Rev: F		Page 1 of 1	

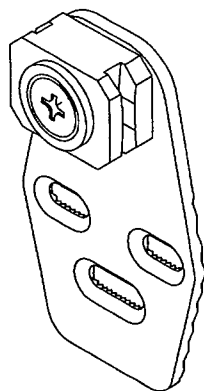
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

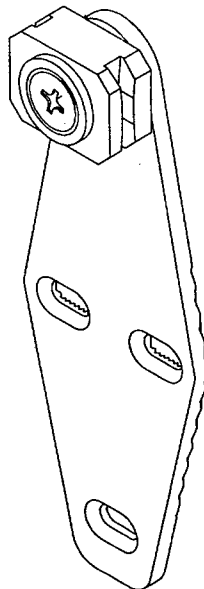
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	0.433	✓			
0.615	+/-0.010	0.625	✓			
0.200	+/-0.010	0.199	✓			
0.600	+/-0.010	0.598	✓			
0.780	+/-0.010	0.790	✓			
Ø 0.500	+/-0.010	Ø 0.500	✓			
0.063	+/-0.010	0.069	✓			
R0.062	+/-0.010	R0.063	✓			
0.162	+/-0.010	0.161	✓			
Ø0.560	+0.008/-0.001	Ø 0.560	✓			
4.21	+/-0.030	4.209	✓			
3.770	+/-0.010	3.773	✓			
1.280	+/-0.010	1.279	✓			
0.700	+/-0.010	0.699	✓			
1.90	+/-0.030	1.890	✓			
100°	+/-0.5°	100°	✓			
2.14	+/-0.030	2.160	✓			
0.262	+/-0.010	0.256	✓			
R0.25	+/-0.030	R0.250	✓			
0.032	+/-0.010	0.030	✓			

Measured by: <u>B.A</u>	Audited by: <u>SL</u>	Prototype Approval:	N/A
Date: <u>09/11/09</u>	Date: <u>09/11/10</u>	Date:	N/A

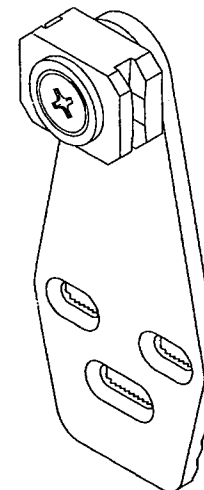
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D3137-045	KJ/JLM	
B	08.12.02	Dwg Rev updated	KJ/DD	
C	09.10.16	Dimension 0.380 & 0.595 removed	KJ	



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY

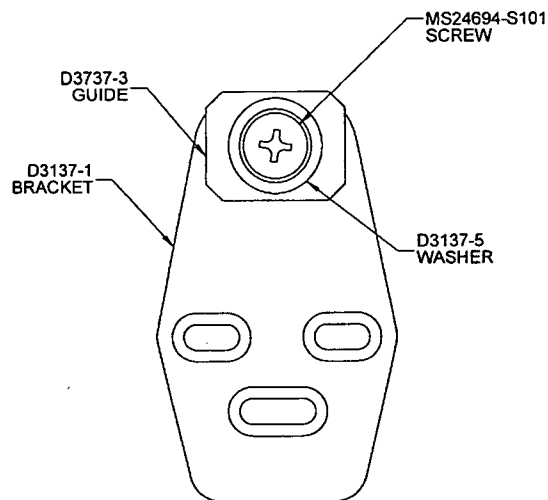


D3137-045 BRACKET ASSEMBLY

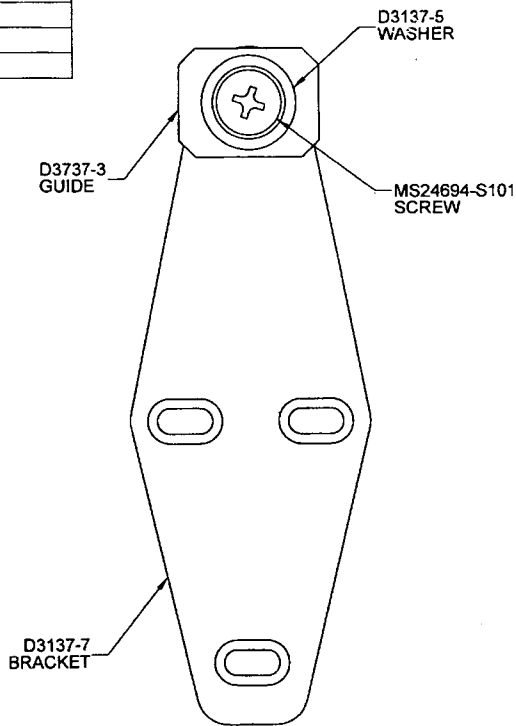
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WORK ORDER
NO. 53040
RL 09-10-22

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48, ZONE A 4 0.480 DIM WAS 0.605, ZONE A 8 0.67 DIM WAS 0.79, ZONE B 5 4.850 DIM WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

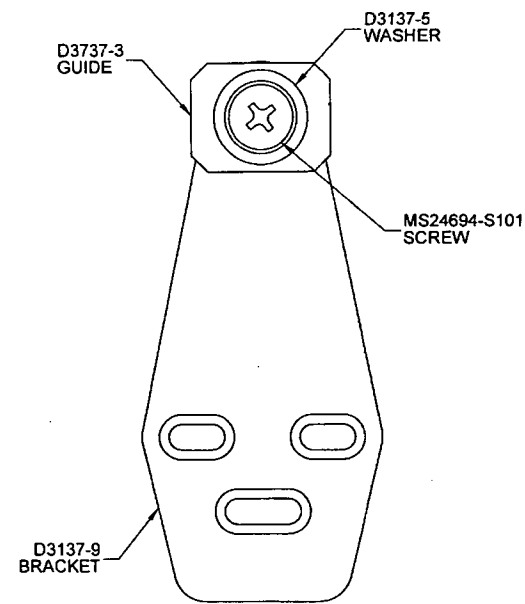
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

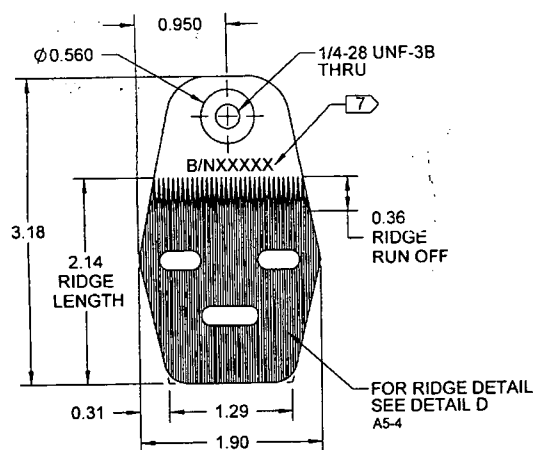
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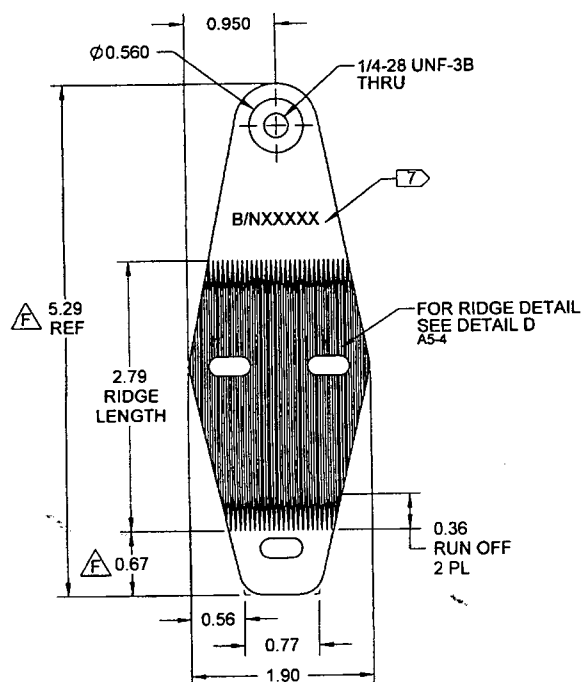
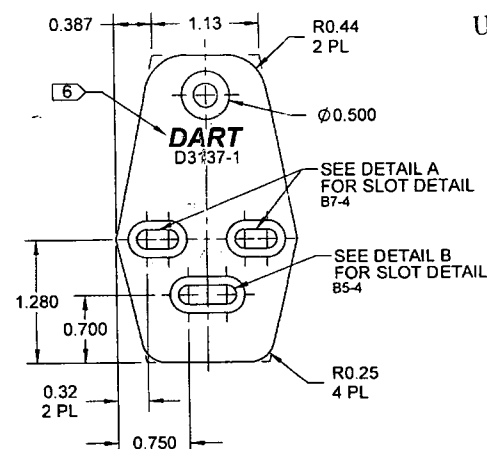
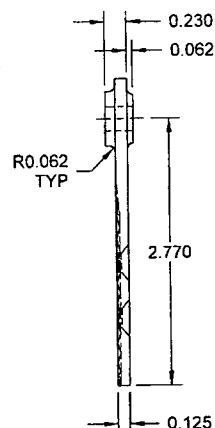
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MFG. APPR.		D3137	SHEET 2 OF 5
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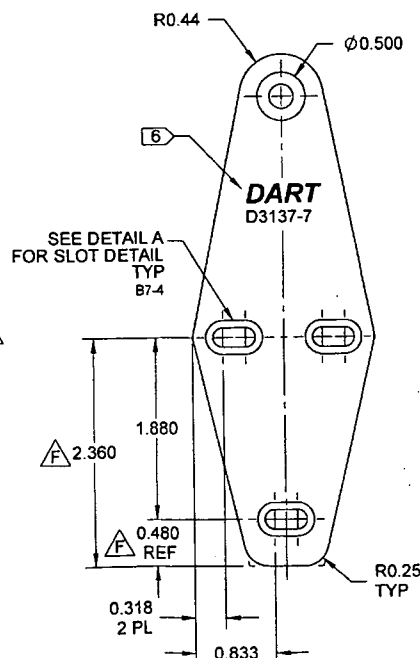
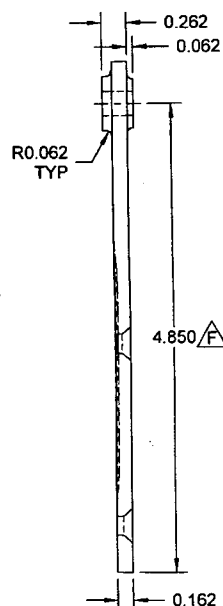
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D3137-1 BRACKET



D3137-7 BRACKET

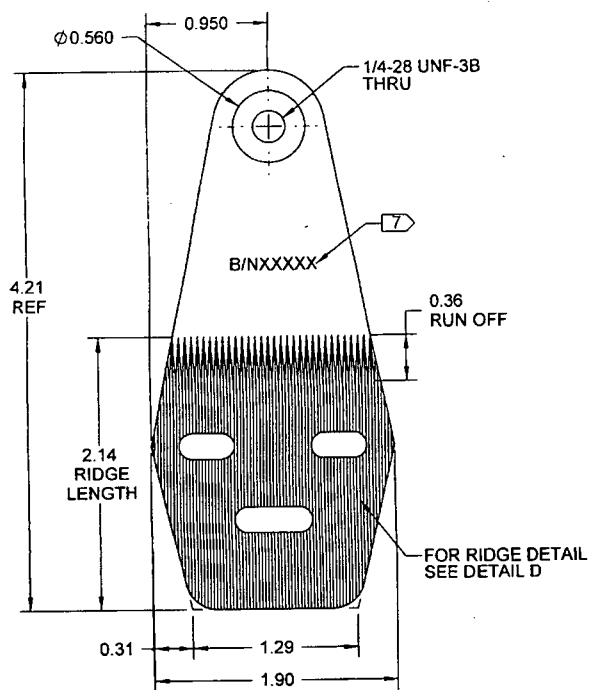


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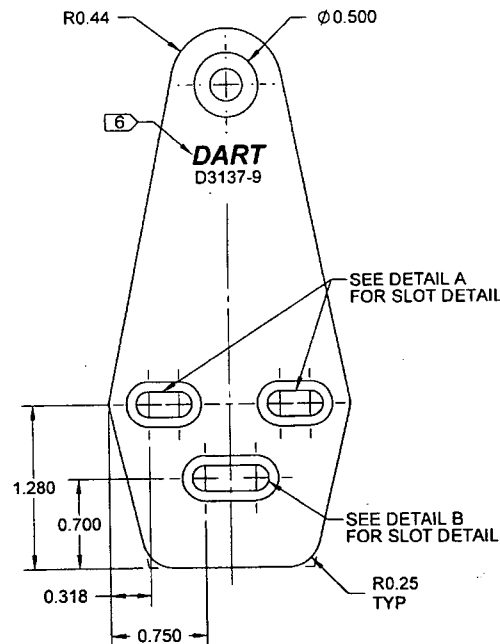
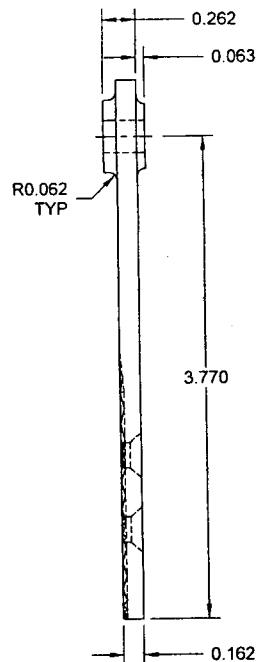
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

RELEASED
08-06-26 144

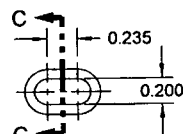
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DATE	08.05.30		



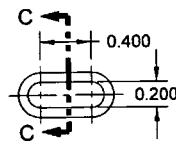
D3137-9 BRACKET



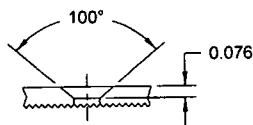
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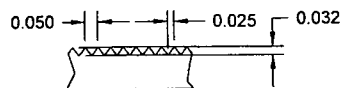
DETAIL A
(SLOT DETAIL)



DETAIL B
(SLOT DETAIL)



SECTION C-C
(SLOT DETAIL)

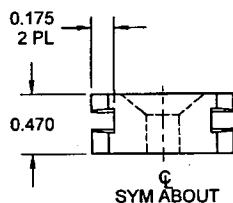
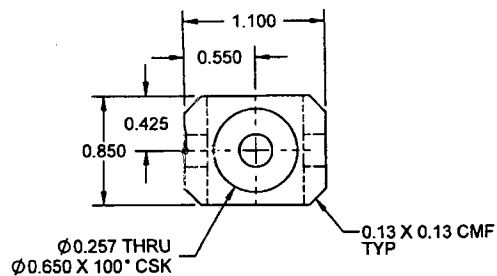


DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)

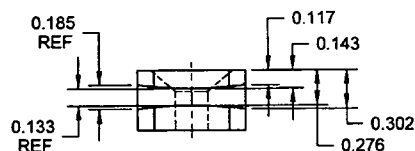
NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/106

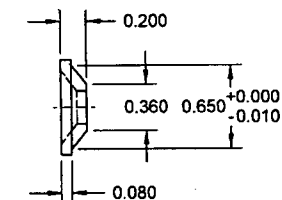
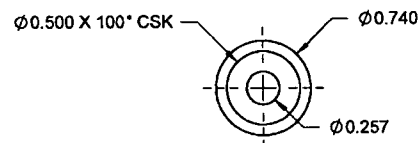
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D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
- 5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

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